

Date: Wednesday, 29/04/2009 3:00:36 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET		
Job Number	: 47595		Part Number	: D2053 BK		
Estimate Number	: 10250		Drawing Number	: D2053 REV C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 29/04/2009	S.O. No. :	Drawing Revision	: C		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 10/05/2009 Qty: 20 Um: Each		
Previous Run	: 38531					
Written By	:					
Checked & Approved By	: JUD 09.04.29					
Comment	: Est D 02.03.18 Added Rev.B NG (Issue this IPP with part number D2052) Est Rev:E now water jet 07-10-25 DD Est Rev:F 08-05-14 chg to revC as per ECN1171 DD verified by:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S090	5052-H32 .090 Sheet	
		Comment: Qty.: 0.0404 sf(s)/Unit Total : 0.8085 sf(s) Material: 5052-H32, 0.090" Thick (M5052H3S.090) Batch: 100782 FB 9-5-26	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2053 Dwg Rev: E FB 9-5-26 Prog Rev: E ****grain direction along 1.987" **** 2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		FB 9-5-26	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:00:36 PM
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Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2053 using CNC Brake

SP 09/05/27 (22)

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter
S 09/05/27 (X22)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005

ump 09/05/27 (X22)

8.0 POWDER COATING POWDER COATING



M 109091

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref 4.3.5.8) as per QSI 005 4.3

START TIME: 3:15pm

OVEN TEMPERATURE: 320°C

FINISH TIME: 3:45pm

ef 09-05-22

(X22)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ef 09/05/28 (23)

(23)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S79

ef 09/05/28 (22)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



09/05/28 (22)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	47S95
Description: BRACKET	Part Number:	D2053
Inspection Dwg: D2053	Rev: C	Page 1 of 1

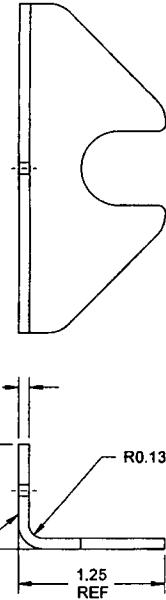
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N
Date:	9-5-26	Date:	09/05/27	Date:	A

Rev	Date	Change	Revised by	Approved
A	...	New Issue	KJ/JLM	

NO.
WORK ORDER
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE



D2053 BRACKET

NOTES:

1) MATERIAL: 5052-H32 ALUMINUM SHEET 0.090 THICK PER QQ-A-250/8 OR AMS 4016
(REF DART SPEC M5052H32S.090)

OR

6061-T6 (OR -T62) ALUMINUM SHEET 0.090 THICK PER QQ-A-250/11 OR AMS 4025/4027
(REF DART SPEC M6061T6S.090)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3

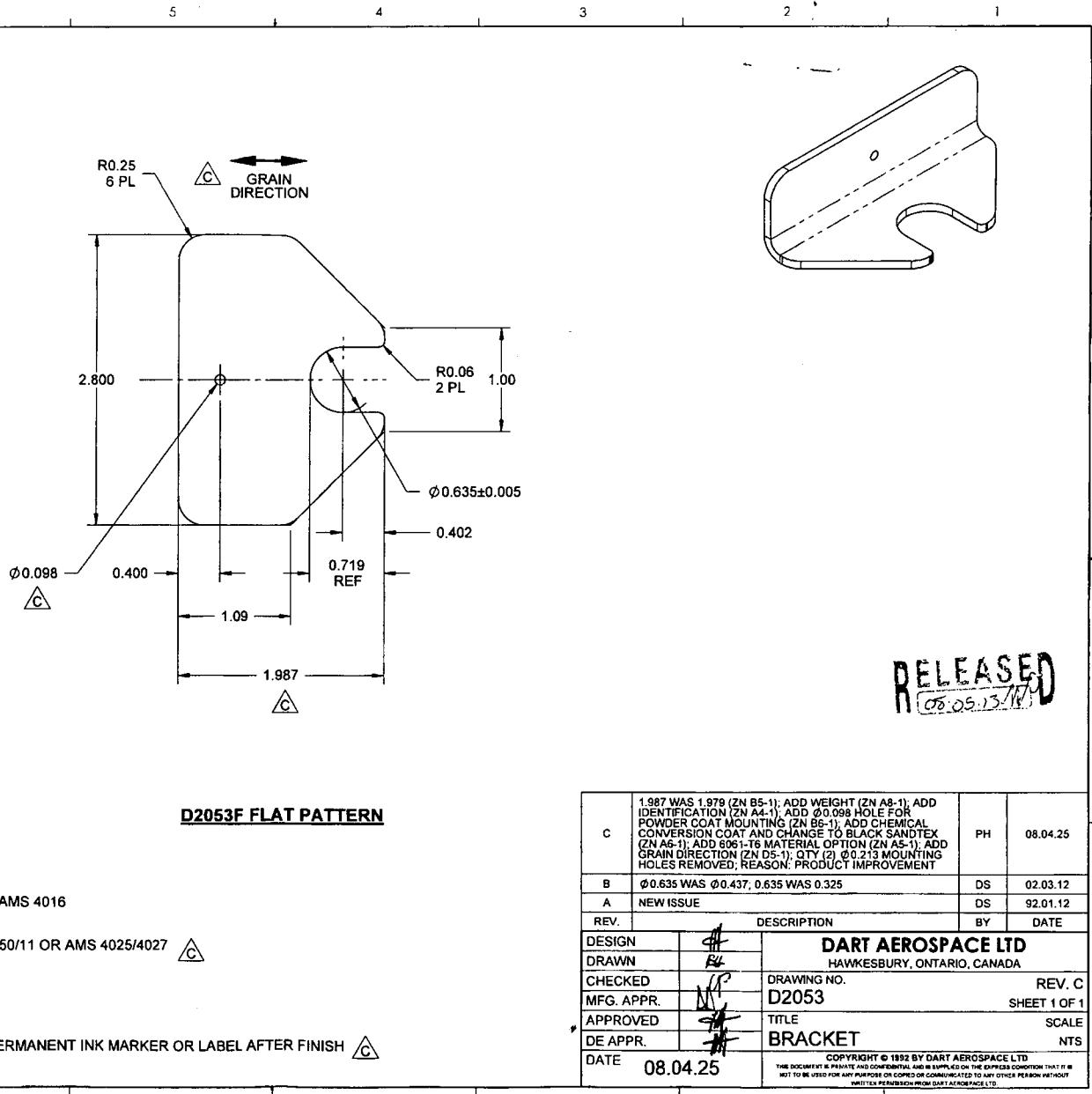
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2053" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH

7) WEIGHT: 0.04 lbs



RELEASED
08.05.13/M